Wörk Ord November-01-1	er ID 9256 2 1:24:51 PM	4		*925	564*			·				Page 1
Item ID: Revision ID: Item Name:	647.1711 Plate		Ä	Accept	*N900	<u>040</u>	100)*	Setup	Start Stop	1 71	S1* S2*
Start Date: Required Date Reference:		Start Qty: 2.00 Req'd Qty: 2.00	* ? * * ? *		Cust Item I Customer:	ID:						
Approvals:		·	Date: \\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \	:		ate:		*; <u>*</u>	Run	Start Stop	1/1	R1* R2*
Sequence ID/ Work Center I		Peration Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision	on Nbr										
647.1700	N/C											
*110				0.00				Z		<u>ට</u>		Janzie
Waterjet FLOW CNC Water	riet	Memo	Dwg (647.17.10)	0.00								of Openier
7075	•	Prog Rev:_	NIC									
		2-Deburr if	necessary									
120	Ç	C2- Inspect parts off n	nachine FAI/FAIB	0.00								
120		Memo		0.00				2		2		Jm212-4

Memo

Quality Control

									DQA:	Date:	
NCR: Yes	/ No				WORK ORDER NON-O	CONFOR	MANCE / UPI	DATE	QA Closed:	Date:	/÷ · · · · · · · · · · · · · · · · · · ·
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No.					Rework Scrap Use-as-is Work Order Update	Ther	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				1	ption of work order update	Initial		ion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	<u>Descr</u>	ription	Date	Verification	QC Inspector
Doc/Data											
quip/Tooling Operator											
Material	1										
Setup	1										
Other											
Process]										
Supplier											
raining											
Inapproved			<u> </u>								
		<u> </u>			F.	AULT CAT	EGORY				

Landing	Gear	General				
	Bending	Bend		Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped.	Burrs		Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
L	Cuffs	Contamination		Maintenance	Part Moved	
	Heat Treat	Countersink		Mislabeled	Positioned Wrong	
	Inspection Strip in Tube	Cut Too Short		Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes		Offset	-	
	Torque Waves in Extrusion	Drawing		Out of Calibration		
	Turning Sequence	Finish		Out of Sequence		
	Wave/Twist in Tube	Folio	Г	Outside Dimensions		

Work Orde November-01-12					*92	564	L*							Page 2	_
Item ID: Revision ID:	647.1711				Accept	*1	1900	040	100)*	Setup	Start	IA.		_
Item Name:	Plate											Stop	*NS	S 2*	
	11/05/12	Start Qty: 2.00		*2*			Cust Item I	D:							
Required Date:	11/13/12	Req'd Qty: 2.00		*2*			Customer:								
Reference:	·								-		D	C4 n ==4			
Approvals:	Process Pl	an:	_ Date:_		Tooling:		Da	nte:			Run	Start	*NI	₹1*	
	QC:		_ Date:_	J	SPC (Y/N):		Da	ite:				Stop	*NI	₹2*	
Sequence ID/ Work Center II	D	Operation Description			Set Up/ Run Hours		Tool ID	Tool #	Plan Code	Accept Qty	t Rej		Reject Number	Insp. Stamp	
130		QC8- Inspect parts - second	ond check		0.00 DAS	À									
130 QC Quality Control		Memo			.000 J3 J3) 05				2					
140		Form as per dwg			0.00									SK	
140 Brake NC Brake NC		Memo	`		0.00					7				/3/8	1
150 +4 • +		QC5- Inspect part comp	leteness to st	ep on W/O	0.00 Sh	\sim				$\hat{}$					
150		Memo			0.00 13-1	. 18				~					

Quality Control

NCR:	Yes	1	No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA:	Date:	>

	•									QA Closed:	Date	e:
Work Orde	r				DISPOSITION			•	AGAINST DE	PARTMENT	PROCESS	
Part N	 			· · · · · · · · · · · · · · · · · · ·	Rework Scrap Use-as-is	Th	ľ	Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	lo				Work Order Update			Large Fab	Composite	·	Supplier	
Root				Descri	ption of work order update	Initia	al	Ac	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief I	Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator						<u> </u>						
Material						<u> </u>						
Setup												
Other	_											
Process		Ė										
Supplier												
Training												
Unapproved		İ										
					F/	AULT CA	ATE	GCIRY				
Landin	ng Gear				General					•	_	
Ļ	Bending				Bend	Gra	iin			Ovalized	ļ	Pressure/Forced
Ļ	Centre N	ot Concer	ntric to	o/s	BOM/Route		dwa			Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged			on Incomplete		Part Incorred	···	Weld
	Crushed/	Crimped.			Burrs	⊢	•	ions Incomplete/	'Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
_	Cuffs				Contamination	\vdash		nance		Part Moved		
	Heat Trea				Countersink	\vdash	labe			Positioned V		_
	Inspectio	•	Tube	<u> </u>	Cut Too Short	—	read	İ	L	Power Loss/	Surge	Other
	Ripples in				Drill Holes	☐ Off						
	Torque W		xtrusio	ր	Drawing	_		Calibration				
	Turning S			<u> </u>	Finish	-		equence				
	Wave/Tw	ist in Tub	e		Folio	Out	side	Dimensions				

Work Ord November-01-1				*925	64*						Page 3
Item ID: Revision ID: Item Name: Start Date:	647.171 Plate 11/05/12		*2*	Accept	*N900		100)*	Setup Sta	IV	S1* S2*
Required Date	: 11/13/12	Req'd Qty: 2.00	*2*		Customer:						
Reference: Approvals:		s Plan:	Date:	Tooling: SPC (Y/N):		ate:	_	1	Run Sta	I/I	R1*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*160 *160* Outsource4 Outsource process	- Anodize	Memo ISSUE P/O		0.00 0.00 AS PER DWG.(SEE NOTE	3)			_C	Z13/	balo4	2
170 *170* Packaging Packaging		Receive & Inspect for E	amage & Mat'l Certs	0.00					1/2] 13/s/l	(4 E

180

Quality Control

Memo

QC5- Inspect part completeness to step on W/O

0.00 **DAS**16
0.00 9-9 73 103/28

												DQA:	Date:	;
NCR:	Yes	/ No				WOR	K ORDER NON-	-CO	NFORI	MANCE / UP	DATE	QA Closed:	Date	
							DISPOSITION				AGAINST D	EPARTMENT		
Work Ord	er:						-				AGAMST D		,	[
Part I	No.						Rework Scrap Use-as-is			Skid-tube Machining noforming	Crosstube Small Fab Finishing	→	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR I	۱o.				·	Wo	ork Order Update			Large Fab	Composite		Supplier	
Root					Desc	ription of v	vork order update	Т	Initial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-co	nformance	Cł	nief Eng	Desc	ription	Date	Verification	QC Inspector
oc/Data														
quip/Tooling														
perator														
/laterial														
etup														
ther														
rocess														
upplier														
raining														
Inapproved														
								FAUL	T CATE	GORY				
Landi	ng (ear				_	General						· · ·	
		Bending			L	Bend			Grain			Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to (o/s	BOM/Ro	oute		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/I	Damaged		Inspecti	or: Incomplete		Part Incorre	ct	Weld
		Crushed/0	Crimped,			Burrs			Instruct	ions Incomplete/	Unclear	Part Lost/M	ssing	Wrong Stock Pulled
		Cuffs				Contamin	nation		Mainte	nance		Part Moved		
		Heat Trea	t			Counter	sink		Mislabe	led		Positioned V	Vrong	<u> </u>
		Inspection	n Strip in	Tube		Cut Too S	hort		Misread	I		Power Loss/	Surge	Other
		Ripples in	Bend			Drill Hole	es		Offset					
		Torque W	aves in E	xtrusior	n [Drawing			Out of 0	Calibration				
		Turning Se	equence			Finish			Out of s	enuence				

Outside Dimensions

Wave/Twist in Tube

Folio

Work Orde November-01-12				*925	664*							Page 4
Revision ID:	647.1711 Plate			Accept	*N900	040	100)* s	etup	Start Stop	*N:	S1*
	11/05/12	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item II Customer:	D:					ı W.	
Reference: Approvals:		an:	Date:	Tooling: SPC (Y/N):		ite:		I	Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
100 SprayPaint Spray Painting		Memo PRIME IAW	v MII -P-23377.J TYPE	0.00 I CLASS N AS PER DWG.	(SEE NOTE 3)			2		<u>Ø</u>	<i>d</i>	13-3-2
Spray ramming				тсн: 1242<i>04</i>	,							
²⁰⁰ *200*		QC14- Inspect Spray Pai	int	0.00 (AS) 0.00 (16)								
QC Quality Control		Memo		0.00 16 9-3	13/03/25							
210 *21 0 *		Identify as per dwg & St	rock Location: MF	0.00								

Memo

IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV

Shipped to Apical

Packaging Packaging

											DQA:	Date	e:,
NCR:	Yes	/ No				WORK ORDER NON-	100	NFORM	//ANCE / UPDAT		QA Closed:	Date	;
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part I	No.					Rework Scrap Use-as-is Work Order Update		f Therm	Machining S noforming	rosstube mall Fab Finishing mposite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		Initial	Action		Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Ch	nief Eng	Description	on	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
							AUL	T CATE	GORY				
Landi		Bending Centre No Cracks Crushed/ Cuffs Heat Trea Inspectio	Crimped. it n Strip in		D/S	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Instruct Mainte Mislabe Misread	or: Incomplete ions Incomplete/Uncle nance led		Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned N Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Ripples in	Bend		l l	Drill Holes	1	Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

	Work Order ID 92564 November-01-12 1:24:51 PM			*925	64*						Page 5
Revision ID:	647.1711 Plate			Accept	*N900	040	100	* S	etup Start	171	S1* S2*
Start Date: Required Date: Reference:	11/05/12 11/13/12	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item I Customer:	D:					
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):		ate:		R	un Star Stop		R1* R2*
Sequence ID/ Work Center II)	Operation Description	Work Order Palance	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*220 *20 *20 *20 Control		QC21- Final Inspection Memo	- WOIR OIGH RElease	0.00					13	3/2	13-03-21

											DQA:	Date:	
NCR:	es/	/ No				WORK ORDER NON-	COI	VFOR	MANCE / UPI	DATE			
											QA Closed:	Date:	·
Nork Order: DISPOSITION								AGAINST DE	PARTMENT	PROCESS			
Part N	•					Rework Scrap Use-as-is		ı	Skid-tube Machining Moforming	Crosstube Small Fab Finishing	-	Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
NCR N	10.					Work Order Update			Large Fab	Composite	(Nec/Stor	Supplier	Other
Root					Descr	iption of work order update	T	nitial	Act	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
oc/Data quip/Tooling perator laterial etup ther													
rocess		:											
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napproved							<u> </u>						
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Landii					_	General		1			7	_	7
	-	Bending				Bend	_	Grain		_	Ovalized	<u> </u>	Pressure/Forced
		Centre No	t Concer	ntric to t	o/s _	BOM/Route	\vdash	Hardwa		-	Over/Under		Temperature/Cure
		Cracks			-	Broken/Damaged	-	1	on Incomplete		Part Incorred		Weld
	_	Crushed/C	rimped.		<u> </u>	Burrs	\vdash	1	ions Incomplete/l	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
ļ	\dashv	Cuffs			-	Contamination	\vdash	Mainte		-	Part Moved		
ļ	႕	Heat Treat			<u> </u>	Countersink	_	Mislabe			Positioned V		٦ .
		Inspection		Tube		Cut Too Short	\vdash	Misread	I	L	Power Loss/	Surge	Other
}	-	Ripples in				Drill Holes	<u> </u>	Offset					
	-	Torque W		xtrusio	` _	Drawing	<u>_</u>	4	Calibration				
	$\overline{}$	Turning Se			<u> </u>	Finish	<u></u>	Out of S	equence		•		
		Wave/Twi	st in Tub	e	1	Folio		Outside	Dimensions				

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Picklist Print

November-01-12 1:24:51 PM

Page 1

Work Order ID:

92564

Parent Item:

647.1711

Parent Item Name:

Plate

Start Date: 11/05/12

Required Date: 11/13/12

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP REV:A 12.10.05 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6S.160		Purchased	No				sf	0.0000		_2.307368	4		
7075-T6 Sheet .160									(-·····	2.4		ж.	Jmn

123644

123644

												DQA:	Date:	
NCR:	Yes	/ No					WORK ORDER NON-O	COI	VFORM	MANCE / UP	DATE			
												QA Closed:	Date:	·————
Nork Ord	er:						DISPOSITION				AGAINST DE	EPARTMENT	PROCESS	
. .						١	Rework]		Skid-tube	Crosstube	_	Water Jet	Engineering
Part	NO.						Scrap			Machining	Small Fab	┥	d. Eng. Coor.	Quality
NCR	No.						Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
												_		
Root					Desc	crip	tion of work order update		nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		0	r Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
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quip/Tooling	L													
perator														
laterial													1	
etup														,
ther														
rocess														
upplier									i					
raining														
napproved														
							F.	AUL	T CATE	GORY				-
Landi	ng (General							_
	<u> </u>	Bending			ļ	-	Bend		Grain			Ovalized	<u> </u>	Pressure/Forced
	_	Centre No	ot Concer	ntric to O)/S		BOM/Route		Hardwa	re	L	Over/Under	tolerance	Temperature/Cure
	<u></u>	Cracks					Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct	Weld
	L	Crushed/0	Crimped.				Burrs		Instruct	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs					Contamination		Mainte	nance		Part Moved		
		Heat Trea	t				Countersink		Mislabe	led		Positioned V	Vrong	_
		Inspection	n Strip in	Tube			Cut Too Short		Misread			Power Loss/	Surge	Other
	L	Ripples in	Bend				Drill Holes		Offset					
		Torque W	aves in E	xtrusion			Drawing		Out of C	Calibration				
	1	Turning So	equence				Finish		Out of S	equence				

Outside Dimensions

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order: 93 92564
Description: Plak	Part Number: 697, 1346
Inspection Dwg: 647, 1700 Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension		Dimension			Inspection	
Ø 0.098°	10.004,	00991	. -	ļ	V	Jimos
<u> 0 201" .</u>	tl-0 005-000		_		V	(,
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Measured by:	JM
Date:	17-12-4

Audited by:		15	
Date:	12	1205	

Preliminary	Approval:		
8	Date:	•	

· · · · · · · · · · · · · · · · · · ·	TENCINEEDING CHANGE NETTO	- 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1	
, DTO AL	ENGINEERING CHANGE NOTICL NO.	02937	SHEET . OF 1
· APICAL	DWG NO. 647.1700 REV: NC PREPAREDJ.	JACKSON DATE: (07/14/10 EFFECT ON DWG
INDUSTRIES, INC.			1 D IVO: W ONLING
TRANSACTION CODES (TC):	APPROVED BY: ENGR STORE MFG DEN BY	- Maurel for	EFF: CURRENT ORDER
A-ADD C-CREATE R-REVISE D-DELETE	REASON: REVISED FIN 8 AND NOTE 3. ADDED	INSPECTION DIMENS	IONS TO DRAWING VIEWS.
SHEET 1, ZONE AL I		SHEET 2,	
	SDIZE IAW MIL-A-8625 IYPE HI CLASS 2, COLOR BLACK; ESOTO PR-148 ADHESION PROMOTER, COLOR BLUE; I-23377J TYPE I CLASS N	ZONE A1	
		SHO C. ENCIPEUS. ENCIPEUS. UNCONTROL! SE C. SUBJECT TO LALEM ME WIGHER NOT. SE WORL OFFER NO. 92564	A -
			7.85 REF
8 R 601.1622 F/N TC PART NUMBER	1 SCREW QTY DESCRIPTION		MS27039-1-14 /
DOCUMENTS EFFECTED:		CHANGE CATEGORY DE	MATERIAL/SPECIFICATION
	□ MDL □ INSTALL INSTRUC □ FMS □ ICA 🛛 B□M	MAJOR MINOR	R REVIEW REQUIRED O YES 🖾 NO

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2 PL (6)

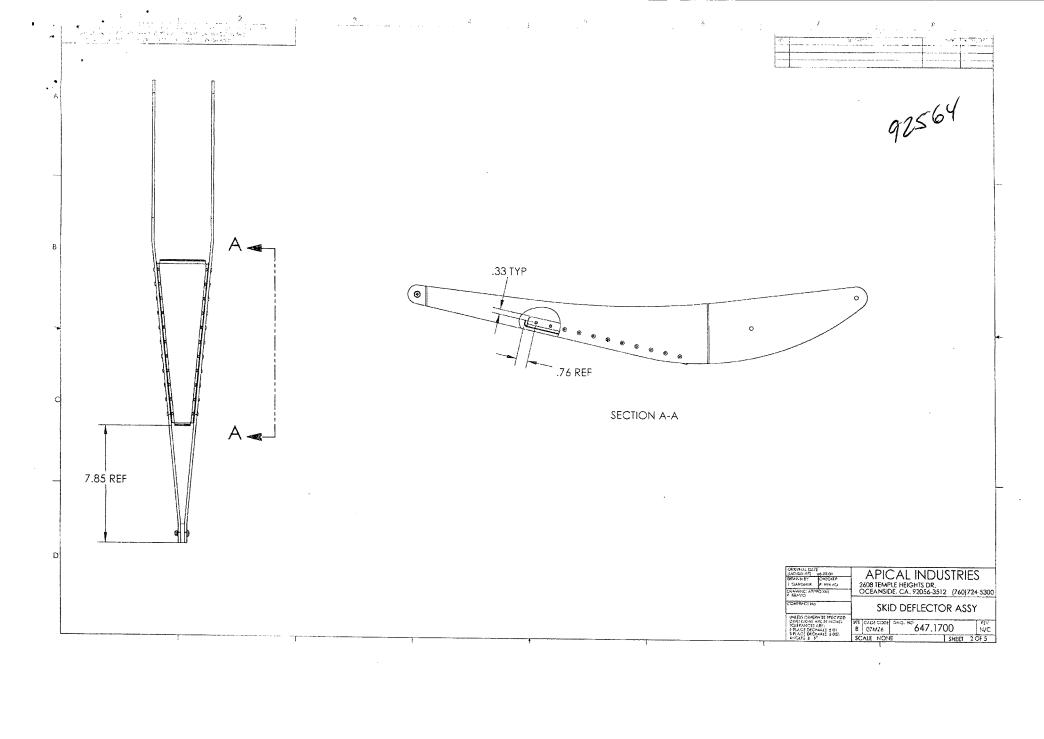
72564

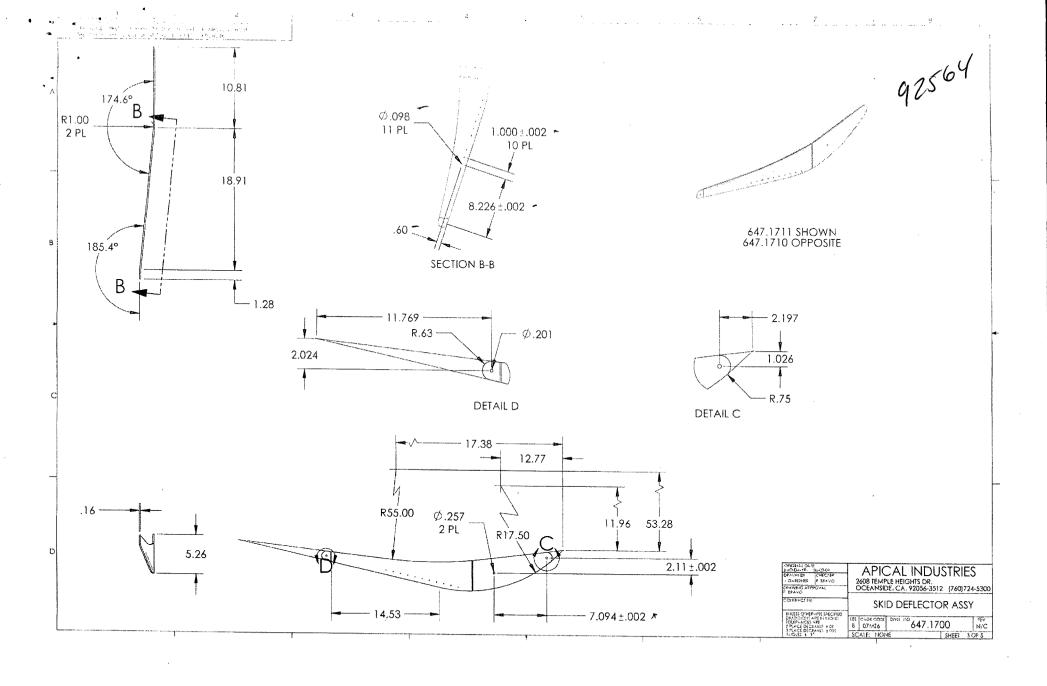
UNINCORPORATED ECN(s)

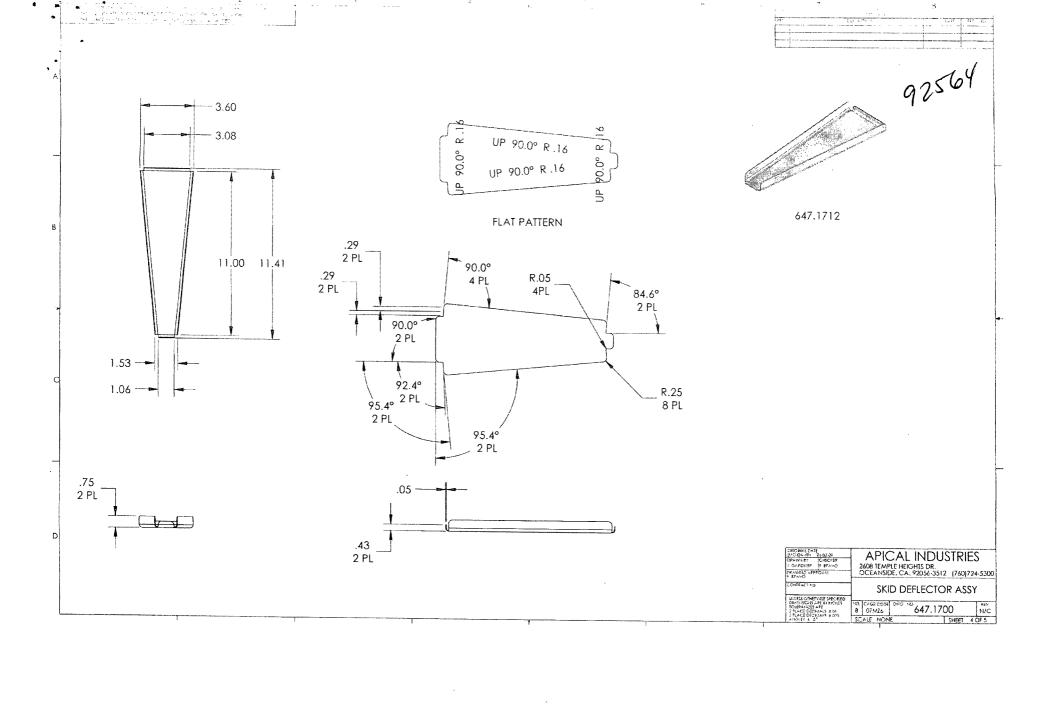
02937

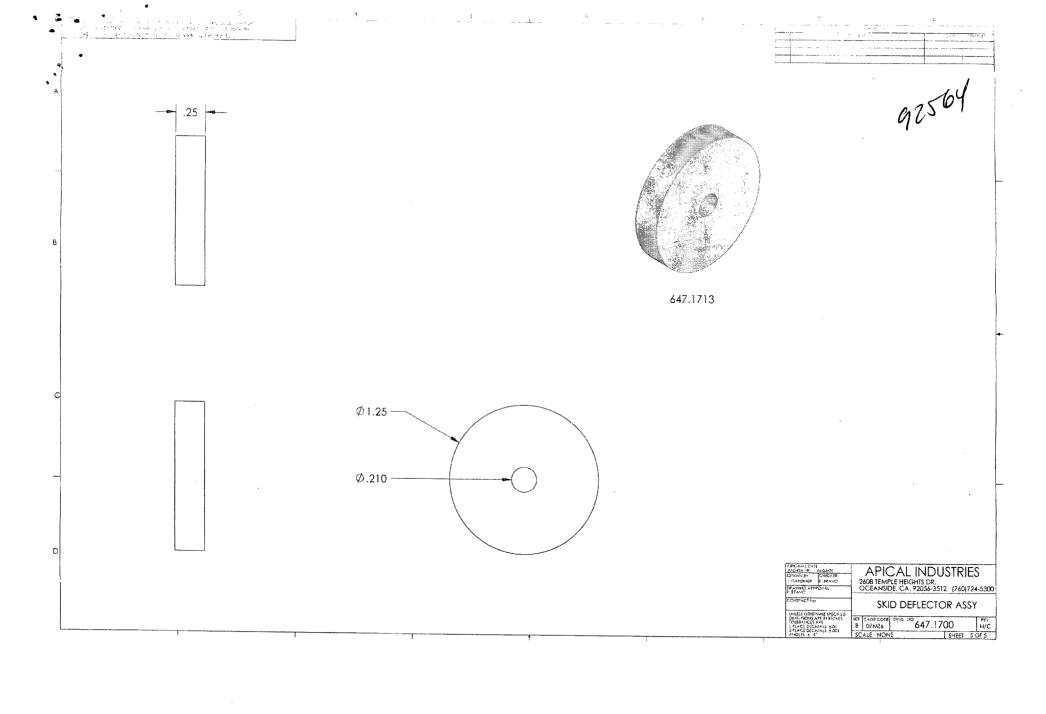
-(5) 22 PL

					1
1	8	601.2637	SCREW	MS32039-1-13	
1	7	601.2943	LOCKNUT	MS21042-3	
2	6	601.1607	WASHER	NAS1149F0332F	
22	.5	601.1915	RIVET	CR3213-4-4	
j	4	647.1713	SPACER	A	A
1	3	647.1712	GUSSET	Δ	Δ
1	2	647,1711	PLATE	Δ	A
1	. 1	647.1710	PLATE	Δ	Δ
		647.1701	SKID DEFLECTOR ASSY		
.1701	FIND #	PART#	DESCRIPTION	MATL.	SPEC.
QTY			PARTS LIST		
NEXT ASSY (647.1300	S) (4.4.	CALLE ORIGINAL DE CALCELLE ORI	APICAL II 2608 TEMPLE HEIGHT OCEANSIDE, CA. 92	S DR.	
		IRA CT sk.	SKID DEFL	ECTOR AS	
	1GL 2 Pi 3 Pi	ESS CIMERANE S'ECHE ENDICHS ARE ACE DECIMALS ±01 ACE DECIMALS ±01 ACE DECIMALS ±01 ACE DECIMALS ±01	THE CARL COOK DWG HO	47.1700 SHEET	nev N/C.











A.T.G. Industries Inc. 731, rue Industrielle Rd. PLATING DEPARTMENT Rockland, On K4K 1T2 Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

Pack List

Number: 62213

Date: 13-Feb-13

То

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 Canada

Ship To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-520	00 Fax: 613-632-1185		013-032-0200	
Terms		Ship Via		
Quantity	Description		D	
1 .	Part: ASST		Rev:	
lot	- noo nooo 4 (
	5 PCS D3299-1 12 PCS D3299-5			
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**************************************	A.T.G. Industries certifies that all items with all requirements, specifications and	in this shipment are in o d drawings referenced in	conformance n the purchase order.	
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